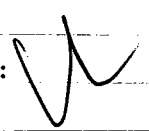


Work Order ID 78078

78078

Page 1

December-28-11 3:15:46 PM

Item ID: D3770-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tube
Start Date: 12/28/11 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 12/29/11 Req'd Qty: 10.00 ***10*** Customer:
Reference: rework
Approvals: Process Plan:  Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3770	Rev B								
120	Chemical Conversion Coat per QSI005 4.1	0.00	<i>M/LIA 12-01-02</i>			10			
120									
HandFinish	Memo	0.00							
Hand Finishing	PULL FROM STOCK: 10 X D3770-1 B67360 ACID ETCH & ALODINE PER DRWG								
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							<i>10 BL 12-01-03</i>
Quality Control									
140	Identify as per dwg & Stock Location: <i>ST 248</i>	0.00							
140									
Packaging	Memo	0.00							<i>(10X) 8p 12-01-03</i>
Packaging	RE-IDENTIFY USING NEW B/N								

Work Order ID 78078***78078***

Page 2

December-28-11 3:15:46 PM

Item ID: D3770-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tube

Stop

NS2

Start Date: 12/28/11

Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/29/11

Req'd Qty: 10.00

10

Customer:

Reference: rework

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

CK 12/01/04

mf
12-01-03

Picklist Print

December-28-11 3:15:46 PM

Page 1

Work Order ID: 78078

Parent Item: D3770-1

Parent Item Name: Tube

Start Date: 12/28/11

Required Date: 12/29/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC
IPP Rev:B Added Drilling Tooling 08-08-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3770-1 Tube		Manufactured	No				Each	5.0000		10		673608/10	W

Location

Loc Qty

Loc Code

ST248

5

56569

2

65060

3

758078

Work Order ID 67360

Wednesday, March 16, 2011 12:04:48 PM



Item ID:	D3770-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tube					
Start Date:	3/16/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	3/23/2011	Req'd Qty:	10.00		Customer:	
Reference:						
Approvals:	Process Plan: <u>H</u>	Date:	11-03-16	Tooling:		Date:
	QC: _____	Date:		SPC (Y/N):		Date:
					Run	Start
						Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3770	Rev B								
100		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-cut tube to lenght as per dwg D3770 2-drill holes thru to finish size as per dwg D3770 Using DT9410, Locate tube on stop labelled #1 and then drill holes labelled #1 3- deburr								
110		0.00							
	QCS- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
120		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

(10X)

⇒ m-l 11/03/16

5ul03/17

(+10)

10 BR 11-3-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67360

Wednesday, March 16, 2011 12:04:48 PM

Page 2

Item ID: D3770-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Tube

Start Date: 3/16/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 ϕ 11/03/21

140

Identify as per dwg & Stock Location: 250

0.00



Packaging

Memo

0.00

Packaging

11/3/22 (1)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/22

MF
11-03-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 16, 2011 12:04:54 PM

Page 1

Work Order ID: 67360

Parent Item: D3770-1

Parent Item Name: Tube



Start Date: 3/16/2011

Required Date: 3/23/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-07-21 revB as per dwg DD verified by:EC
IPP Rev:B Added Drilling Tooling 08-08-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6T1.000W065

Purchased

No

100

f

50.5728

1.1358

11.95579



6061T6 RD TUBE 1.00 x .065w

M-J 11/03/16

Location

Loc Qty

Loc Code

MAT015

50.57283748

113511

13.7388405

114089

9.228737

116720 ✓

27.60526

11-95579

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

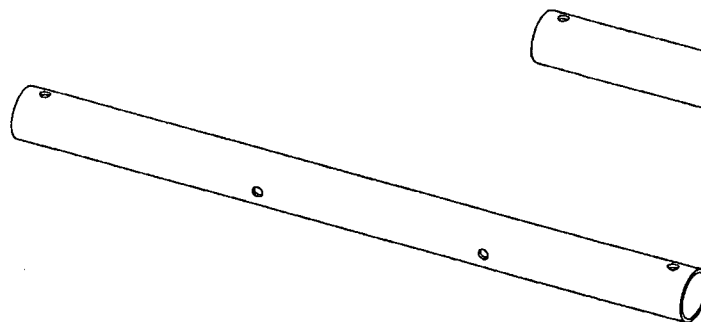
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

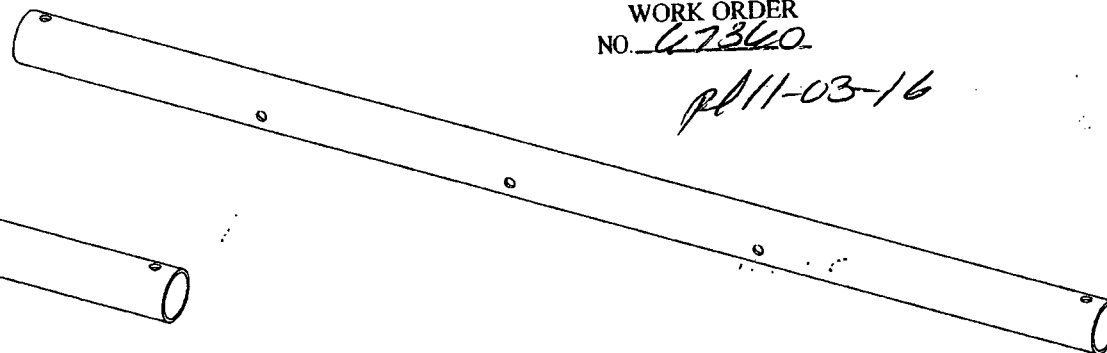
NOTE: Date & initial all entries

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 47340

08-03-16



D3770-1 TUBE



D3770-3 TUBE

08-07-10/1A

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3770-1, 0.25 lbs
 D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3770	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE	NTS
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS HEREBY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT OR THE INFORMATION CONTAINED THEREIN IS TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	